	er ID 70232 e 01, 2011 11:07:12 AM							AS	AP		Page 1
Revision ID:	D3255-042		Accept				S	•			
	Access Panel Assembly 6/1/2011	. (#4141 1141 1441		Cust Item Customer:	ID:						
Approvals:	Process Plan: MP QC:	Date: 1 -06-0	Tooling: SPC (Y/N):		ate:		F				
Sequence ID/ Work Center II	Operation Description	THE CONTRACTOR OF THE PROPERTY	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		ect nber	Insp. Stamp
Draw Nbr	Revision Nbr				y 30 A 44			•			
D3255	Rev B										
Large Fab	Large Fab Memo 1-Wele Batch:	i as per Dwg D3255 ***purge	0.00 0.00 e weld***□A/R SS R0 d Welds Flush	DD	6	0	06	-01		/x	
QC Quality Control	QC10- Inspect visu Mem o	al per QSI004- ground welds	0.00 8 /(106107				·		,	
120 QC Quality Control	QC5- Inspect part of	completeness to step on W/O	0.00 Sul	46 log			-04)			

7 P.

-411710	oopaoo .								
W/O:		4,000,000	WO	RK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHAP	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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·····									
Part No	•	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date:	
	Re	solution:	Disposition	l:	QA: N/C C	osed:		Date: _	
NCR:		• 1	WORK ORDE	R NON-CONFORMAN	NCE (NCF	?)-			
DATE	OTED	Description of NC		Corrective Action Section		Verifi	cation	Approval'	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
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W	ork	Or	der	ID	70232
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Wednesday, June 01, 2011 11:07:12 AM



Page 2

Item ID:

D3255-042

Accept

Setup Start

Stop



Revision ID:

Item Name:

Required Date: 6/2/2011

Access Panel Assembly

Start Date:

6/1/2011

QC:

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date: Tooling:

SPC (Y/N):

Date:

Date:

Start Run



Stop

Sequence ID/ Work Center ID

130

Powdercoat

Powder Coating



Quality Control

Operation Description

Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

QC3- Inspect Part Finish

0.00

Memo

0.00

1 & BR 11-6-2

150



Small Fab Small Fab

Small Fab

0.00

0.00

Ss u (oclo 3

I-Bond D3255-5 gasaket to d3255-042 using Dow corning adhesive as per Dwg

D3255□A/R 736

DOW CORNING ADHESIVE

Batch: MILGGGC

DuitAci	OSPACE	- In Co.								
W/O:			Wo	RK ORDER CHANGE	ES					
DATE	STEP	PRO	CEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Categ	jory:	NCF	: Yes I	No DQA	/ :	Date:	
	R	esolution:	Disposition):	_ QA:	N/C Clo	sed:		Date: _	TO THE STATE OF TH
NCR:		\	VORK ORDE	R NON-CONFORMA	NCE	(NCR))			
DATE	STEP	Description of NC		Corrective Action Section	on B		Verific	ation	Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector
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Work Order ID 70232

Wednesday, June 01, 2011 11:07:12 AM



Page 3

Item ID:

D3255-042

Accept

Setup Start



Revision ID:

Item Name:

Required Date: 6/2/2011

Access Panel Assembly

Start Date:

6/1/2011

Start Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Req'd Qty: 1.00

Date: _____

Tooling:

Date:

Run

Start

Stop



QC:

Date: _____

SPC (Y/N):

Date:

Stop

Reject

Sequence ID/ **Work Center ID**

160

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours**

Tool ID

Tool # Plan Code

Accept Qty

Reject **Qty**

Insp. Number Stamp

170

1. .

Packaging Packaging

Identify as per dwg & Stock Location:

Memo

Memo

PPP 70233

0.00

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

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W/O:		,	W	ORK ORE	DER CHAI	NGES					
DATE	STEP	PROCE	DURE CH	ANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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Part No		PAR #:	Fault Cat	egory:		NC	R: Yes	No DQA	/ :	_ Date: _	
	R	esolution:	Dispositi	on:		QA	: N/C C	osed:		Date: _	
NCR:		WC	ORK OR	DER NON-	-CONFOR	MANCE	(NCF	(3)			
		Description of NC		Corrective	Action	Section B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Actio	on Description Chief Eng	on	Sign & Date	Section		Chief Eng	QC Inspector
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Picklist Print

Wednesday, June 01, 2011 11:07:09 AM

Work Order ID: 70232

Parent Item:

D3255-042

Parent Item Name: Access Panel Assembly



Start Date: 6/1/2011

Required Date: 6/2/2011

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ tem Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	- *	Date ssued	Status
3255-2		Manufactured	No			100	Each	7.0000		1 GC	11.06.01		
				Location	1	Loc C	<u>Otv</u>	Loc Code		•			
	•			WA	69054		6 6	-	vagoran.		• .		
		·		WA025	61686		1				-		
3255-3 ap		Manufactured	No		<i>:</i> .	150	Each	17.0000		10	(plipolo	-01	
				Location WA021		Loc (17	Loc Code		<u>س</u>	·		
3255-5		Manufactured	No		66812	100	17 Each	14.0000	1	\$ 0	10 6/0-	}	
				Location	. `	Loc (Qt <u>y</u>	Loc Code					
				GA			14				-		
					66574		2			1			

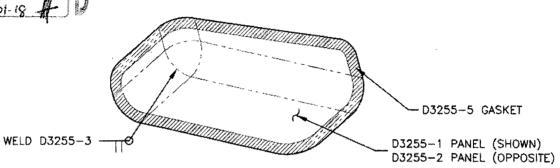
Page 1

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W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	•	gory:	NCR: Yes	No DQ	A:	Date: _	
	R	esolution:	Dispositio	n:	_ QA: N/C (closed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	on B Sign		cation	Approval Chief Eng	Approval QC Inspector
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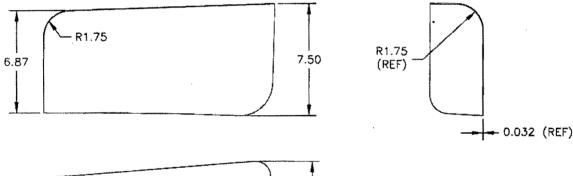


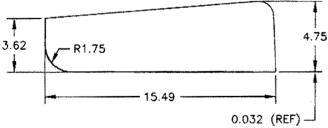
C	DESIGN THE	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
C	CHECKED 10	APPROVED		REV. B
	ч.	-	D3255 SHEET	1 OF 4
C	DATE		TITLE	SCALE
	04.12.06		ACCESS PANEL ASSEMBLY	1:6
	Α	04.01.27	NEW ISSUE	
	В	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	





D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)





D3255-1 BEND DETAIL D3255-2 OPPOSITE

D3255-041/-042 NOTES:
1) WELD PER DART QSI 004

2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE

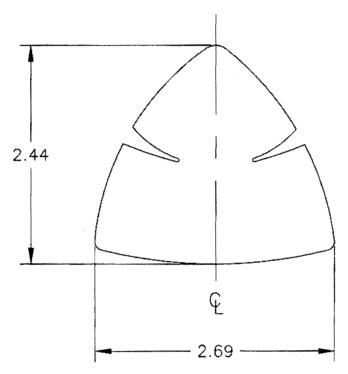
WITH MANUFACTURE'S INSTRUCTIONS
4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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W/O:			WO	RK ORDER C	HANGES				,	
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:								
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DATE	STEP	Description of NC		Corrective Action			Verifi	cation	Approval	Approval
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04.12.06		TITLE	1:1





D3255-3 CAP FORM TO FIT D3155-1/-2

D3255-3 NOTES:

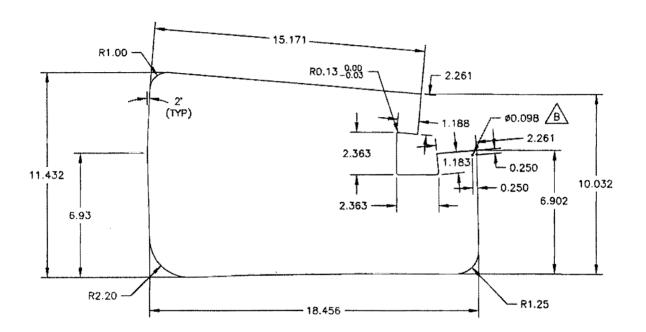
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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W/O:			V	ORK ORDER CHANG	ES	***************************************				
DATE	STEP	PRO	CEDURE CH	IANGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Ca	tegory:	_ NCR: \	Yes N	o DQ .	A:	Date:	
	R	esolution:	Disposit	ion:	_ QA: N/	C Clos	sed:		Date: _	
NCR:		V	VORK OR	DER NON-CONFORMA	ANCE (N	NCR)				
DATE	STEP	Description of NC			ion B	: 0		cation	Approval	Approval
	-	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti	ion C	Chief Eng	QC Inspector
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04.12.06		ACCESS PANEL ASSEMBLY	1:5





D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

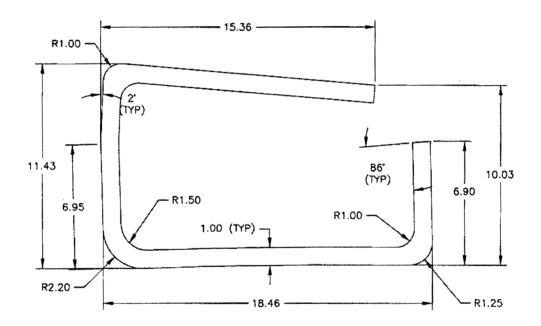
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

W/O:			W	ORK ORDER CHAN	GES			-		
DATE	STEP	PRO	CEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC		Corrective Action Section B		Verificati				
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DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5





D3255-5 GASKET

- <u>D3255-5 NOTES:</u>
 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F P/N SIL/F 36x36x1/16 POSSIBLE SUPPLER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES

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W/O:			WO	RK ORDER CHANG	ES	-				
DATE STEP		PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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